

# Work Order ID 51900

Wednesday, September 09, 2009 11:03:54 A



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*By: [Signature]*

Date: 09-9-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

*Sorlulo*

*HJ for BG 09/10/08*

51900

**Work Order ID 51900**

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Item ID: D350-636-011

Accept

Setup Start

Revision ID: F

Stop

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

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Required Date: 9/18/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

110

0.00



Skidtubes

Skidtubes

Skidtubes

**Memo**

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

M111682

10-Grind welds flush as per Dwg D2750

DP 9-9-28

BE 09/09/17

M111682 BE 09/09/17

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Item ID: D350-636-011

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

12- Scribe batch# inside per dwg D2750

DP 9-9-28

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

27 S 09/09/28

Memo

0.00

70

4

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

27 S 09/09/28

Memo

0.00

70

4

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

m

09

09

28

11

# Work Order ID 51900

Wednesday, September 09, 2009 11:03:54 A



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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 160                            |  | 0.00                 |                |              |              |               |               |                  |                |
|                                | Skidtubes  |                      |                |              |              |               |               |                  |                |
| Skidtubes                      | <b>Memo</b>  | 0.00                 |                |              |              |               |               |                  |                |
| Skidtubes                      | 1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)<br>as per dwg D2750.   |                      |                |              |              |               |               |                  |                |
|                                | 2-Open up holes of Detail B to 0.750" (total of 4 holes per side)<br>as per dwg D2750.   |                      |                |              |              |               |               |                  |                |
|                                | 3- Open float hole to 0.500" (4 per side)  |                      |                |              |              |               |               |                  |                |
|                                | 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750<br>(welding instructions on sheet 8)   |                      |                |              |              |               |               |                  |                |
|                                | 5-Deburr and blow out all chips from inside of tube  |                      |                |              |              |               |               |                  |                |
|                                | 6- Prepare tube for welding, remove alodine as required.   |                      |                |              |              |               |               |                  |                |
|                                | 7-Bond web D2739 in place as per QSI 015<br>A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>H112391</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>exp. date: <u>02/20/2010</u> |                      |                |              |              |               |               |                  |                |
|                                | 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004<br>(welding instructions on sheet 8)<br>A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>H109213</u>   |                      |                |              |              |               |               |                  |                |
|                                | 9-Grind welds flush as per Dwg D2750   |                      |                |              |              |               |               |                  |                |
|                                | 10-Spot face ground handling holes section (total of 4 places per side) as per<br>dwg D2750  |                      |                |              |              |               |               |                  |                |

DP 9-9-28

DP 9-9-28

AD 09.09.29

DP 9-9-30

**Work Order ID 51900**

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Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

11-Deburr holes

DP 9-9-30

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) 8 09/09/30

(X)

/

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 09/09/30

(X)

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

H 09/09/01

(X)

10

**Abstract**

Wednesday, September 09, 2009 11:03:54 A

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52

**Abstract**

(b) (7)(C), (b) (7)(D)

**Customer:**

**Reference:**

[illegible]

**1**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

AN112260

0.00

START TIME: 9:15 AM  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:45 AM

0.00

0.00

Inspect for foreign object per QSI 024

0.00

0.00

## Hand Finishing

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Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: W/R

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m112391EXP DATE: 10/20

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: m1012235-Coat all exposed fasteners with "LPS Procyon" batch: m104251

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 509/10/08

MO 09/10/07

(71)

6

P/E  
→  
[scribbles]

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: Skred tubes NCR: Yes No DQA: \_\_\_\_\_ Date: 05.10.14  
 Resolution: re-work Disposition: re-work QA: N/C Closed: \_\_\_\_\_ Date: 05.10.14

| NCR: <u>51900</u> |                                   | WORK ORDER NON-CONFORMANCE (NCR)  |                             |  |                                |                           |                       |                                |
|-------------------|-----------------------------------|---|-----------------------------|--|--------------------------------|---------------------------|-----------------------|--------------------------------|
| DATE              | STEP                              | Description of NC<br>Section A  | Corrective Action Section B |  |                                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector       |
|                   |                                   |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date                 |                           |                       |                                |
| 9/10/02           | Revised<br>@<br>step<br>#<br>230. | Found during Assembly that<br>the holes at section AS-AS<br>are too small. The welder<br>didn't use the right drill bit   | <i>[Signature]</i>          | - Drill out x-bolt spacer to<br>φ. 40mm (Y drill) + Deburr<br>- touch up Alodine as required | <i>[Signature]</i><br>09.10.02 | <i>[Signature]</i>        | <i>[Signature]</i>    | <i>[Signature]</i><br>09/10/02 |
|                   |                                   | No Drill out the x-bolt spacer.<br>It wasn't seen at inspection also<br>in experience at weld. (Didn't know)<br>and no inside hole dim. on spec.<br>PC: Human error | <i>[Signature]</i>          | - touch up with mmm as AS1004  | <i>[Signature]</i><br>09-10-02 | <i>[Signature]</i>        | <i>[Signature]</i>    | <i>[Signature]</i><br>09/10/02 |
|                   |                                   |   |                             |  |                                |                           |                       |                                |

NOTE: Date & initial all entries



**Work Order ID 51900**

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Item ID: D350-636-011

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Revision ID: F

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Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

9/10/8 @ 50

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

2) 80210/08



270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Package as per PPP D350-636-011

G

9/10/08 @ 50

**Work Order ID 51900**

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

PL 09-10-5

# Picklist Print

Wednesday, September 09, 2009 11:04:01 AM

Page 1

Work Order ID: 51900

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2744RevC  |                        | Manufactured  | No          |                     |                  | 110             | Each               | 50.0000        | 1.0000                   |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Cap  |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

50

44892

15

47488

35

D2600-3-BENTRevD1 Manufactured No



Extrusion Bent

D2743RevB Manufactured No



Crossbolt Spacer

110 Each 0.0000 1.0000

★

1

BE 09/09/17



★ B 50675 (1) 25 09/09/17

160 Each 294.0000 8.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

AWM 9-9-29

AWM 9-9-29

(5)

(5)

# Picklist Print

Page 2

Wednesday, September 09, 2009 11:04:01 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2739RevD                       |                        | Manufactured  | No          |                     |                  | 160             | Each               | 6.0000         | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

350 I Beam

B52305  
DP 9-9-28

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| LG               | 4              |                 |
| 50353            | 4              |                 |
| Main Warehouse   |                |                 |
| ST               | 2              |                 |
| 47124            | 1              |                 |
| 47681            | 1              |                 |

D3490-3RevA

Manufactured No



Cross Bolt Spacer

160 Each 112.0000 4.0000



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 112            |                 |
| 45560            | 22             |                 |
| 47471            | 35             |                 |
| 48276            | 55             |                 |

ALWM 9-9-29 (4)

# Picklist Print

Wednesday, September 09, 2009 11:04:01 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3490-1RevA                     |                        | Manufactured  | No          |                     |                  | 160             | Each               | 165.0000       | 4.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Cross Bolt Spacer               |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|       |     |  |
|-------|-----|--|
| ST    | 165 |  |
| 45338 | 2   |  |
| 47118 | 4   |  |
| 47657 | 50  |  |
| 48277 | 109 |  |

AW m 9-9-09 (4)

ALS4-1032-225

Purchased

No



220

Each

8,753.000

38.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|        |      |  |
|--------|------|--|
| ST     | 8753 |  |
| 107441 | 16   |  |
| 110768 | 8737 |  |

X 38 mD 09/10/05

D3492-041RevC

Manufactured

No



230

Each

3.0000

8.0000



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|       |   |  |
|-------|---|--|
| ST    | 3 |  |
| 43816 | 3 |  |

x8 mD 09/10/05

# Picklist Print

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Wednesday, September 09, 2009 11:04:01 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3793-3RevA                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 22.0000        | 1.0000                   |               |                |        |



Wearshoe

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

22

47720

11

50216

11

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

167

102180

1

106896

1

110105

65

110847

100

X1

MO 09/10/05

X1

MO 09/10/05

# Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3793-1RevA                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 18.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Wearshoe                        |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

D3488-041RevB

Manufactured

No

230

Each

29.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

41853

1

44530

8

47348

20

X1 MO 09/10/05

X1 MO 09/10/05

# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3794-3RevA                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 27.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Gasket                          |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

|       |    |  |
|-------|----|--|
| ST    | 27 |  |
| 46531 | 2  |  |
| 47440 | 2  |  |
| 47722 | 11 |  |
| 50240 | 12 |  |

AN6C44A

Purchased

No

230

Each

172.0000 4.0000



BOLT

Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

|        |   |  |
|--------|---|--|
| FG     | 2 |  |
| 103964 | 2 |  |

Main Warehouse

|        |     |  |
|--------|-----|--|
| ST     | 170 |  |
| 110105 | 4   |  |
| 110155 | 14  |  |
| 110665 | 1   |  |
| 110865 | 51  |  |
| 111605 | 50  |  |
| 111649 | 50  |  |

112720

X1 MD 09/10/05

X3 MD 09/10/05  
X1



# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21083C8<br>                   |                        | Purchased     | No          |                     |                  | 230             | Each               | 90.0000        | 1.0000<br>               |               |                |        |
| NUT                             |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

|        |    |  |
|--------|----|--|
| ST     | 90 |  |
| 110584 | 5  |  |
| 111424 | 2  |  |
| 111637 | 21 |  |
| 112243 | 42 |  |
| 112492 | 20 |  |

XL MD 09/10/05

D3536-25RevA

Manufactured No



230 Each 21.0000 1.0000



Gasket

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

|       |    |  |
|-------|----|--|
| ST    | 21 |  |
| 45569 | 1  |  |
| 47011 | 2  |  |
| 47526 | 8  |  |
| 50266 | 10 |  |

XL MD 09/10/05

# Picklist Print

Page 8

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3631-1RevA                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 105.0000       | 8.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Washer

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 105            |                 |
| 38139            | 6              |                 |
| 45353            | 16             |                 |
| 47437            | 83             |                 |

51900

X8 mp 09110/05

D3791-1RevA

Manufactured No

230

Each

18.0000

1.0000



Wearplate

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 18             |                 |
| 47536            | 8              |                 |
| 50269            | 10             |                 |

50269

XI mp 09110/05

# Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960C10L<br><br>washer |                        | Purchased     | No          |                     |                  | 230             | Each               | 7,340.000      | 38.0000                  |               |                |        |

WarehouseLoc QtyLoc CodeLocation

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

7284

112116

2284

112612

5000

~~X38~~ mo 09/10/05

Wednesday, September 09, 2009 11:04:02 AM

Shop Packet Print

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# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2745RevB                       |                        | Manufactured  | No          |                     |                  | 230             | Each               | 272.0000       | 8.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Bushing                         |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|       |     |
|-------|-----|
| ST    | 272 |
| 34817 | 2   |
| 36230 | 8   |
| 37303 | 1   |
| 39587 | 2   |
| 40726 | 2   |
| 41114 | 2   |
| 42778 | 19  |
| 43754 | 2   |
| 44893 | 37  |
| 45556 | 69  |
| 46695 | 18  |
| 48278 | 110 |

AN3C5A

Purchased

No

230

Each

642.0000

34.0000



Bolt

XO mp 09/10/05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

|        |     |
|--------|-----|
| ST     | 642 |
| 111424 | 8   |
| 111707 | 334 |
| 112314 | 200 |
| 112489 | 100 |

X 34 mp 09/10/05

# Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3537-1RevC                     |                        | Manufactured  | No          |                     |                  | 230             | Each               | 45.0000        | 3.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Wearpad                         |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

45

48288

2

50321

43

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000



Plug Assembly

51642

X3 mp 09/10/05

X1 mp 09/10/06

X8 mp 09/10/05

# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

|        |  |           |    |  |  |     |      |           |        |  |  |  |
|--------|--|-----------|----|--|--|-----|------|-----------|--------|--|--|--|
| AN3C6A |  | Purchased | No |  |  | 230 | Each | 1,048.000 | 4.0000 |  |  |  |
|--------|--|-----------|----|--|--|-----|------|-----------|--------|--|--|--|



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1048

110372

72

111982

976

X4

mo 09/10/05

|             |  |           |    |  |  |     |      |          |        |  |  |  |
|-------------|--|-----------|----|--|--|-----|------|----------|--------|--|--|--|
| NAS1611-013 |  | Purchased | No |  |  | 230 | Each | 320.0000 | 1.0000 |  |  |  |
|-------------|--|-----------|----|--|--|-----|------|----------|--------|--|--|--|



O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

X8

mo 09/10/05

|             |  |           |    |  |  |     |      |          |        |  |  |  |
|-------------|--|-----------|----|--|--|-----|------|----------|--------|--|--|--|
| NAS1611-010 |  | Purchased | No |  |  | 230 | Each | 345.0000 | 1.0000 |  |  |  |
|-------------|--|-----------|----|--|--|-----|------|----------|--------|--|--|--|



O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

He

| W/O: 51900 |      | WORK ORDER CHANGES  |    |          |     |                                     |                          |
|------------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE  | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 09/10/05   |      | Replaced O-Ring NAS 1611-010 by O-Ring<br>D 2594-3 Batch <u>851613</u> X8 | md | 09/10/05 | 8   |                                     | 30/07/07<br>3            |
|            |      |   |    |          |     |                                     |                          |

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3535-25RevB                    |                        | Manufactured  | No          |                     |                  | 230             | Each               | 11.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 11             |                 |
| 47523            | 11             |                 |

51603

X1 09/10/05  
MD

D3794-1RevA

Manufactured No



230 Each 33.0000 1.0000



Gasket

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 33             |                 |
| 46530            | 1              |                 |
| 47212            | 2              |                 |
| 47721            | 4              |                 |
| 51668            | 26             |                 |

X1 MD 09/10/05

Wednesday, September 09, 2009 11:04:02 AM

Shop Packet Print

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# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21043-6<br> |                        | Purchased     | No          |                     |                  | 230             | Each               | 1,132.000      | 4.0000                   |               |                |        |
| NUT   |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

xy      m10 09/10/05

S D3493-1RevA

Manufactured      No



Washer

260

Each

115.0000      2.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

115

44902

15

47710

100

97710      9/10/08      128

# : Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21083C8<br>S                  |                        | Purchased     | No          |                     |                  | 260             | Each               | 90.0000        | 2.0000                   |               |                |        |
| NUT                             |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 90             |                 |
| 110584           | 5              |                 |
| 111424           | 2              |                 |
| 111637           | 21             |                 |
| 112243           | 42             |                 |
| 112492           | 20             |                 |

112243 54

AN8C21A



BOLT

Purchased

No

260

Each

110.0000

2.0000



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 110            |                 |
| 105160           | 1              |                 |
| 107596           | 1              |                 |
| 107924           | 2              |                 |
| 109092           | 2              |                 |
| 110341           | 2              |                 |
| 110342           | 2              |                 |
| 111605           | 50             |                 |
| 111684           | 50             |                 |

111684

9/10/8

DS

# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960C816L<br><br>WASHER        |                        | Purchased     | No          |                     |                  | 260             | Each               | 330.0000       | 2.0000                   |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 330            |                 |
| 104093           | 2              |                 |
| 107520           | 4              |                 |
| 110139           | 29             |                 |
| 110372           | 36             |                 |
| 110584           | 100            |                 |
| 111424           | 159            |                 |

~~260~~ 111424 SD

NAS1515H3L

Purchased

No



WASHER

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| OFFSHORE         |                |                 |
| FG               | 40             |                 |
| 102472           | 40             |                 |
| Main Warehouse   |                |                 |
| ST               | 310            |                 |
| 110450           | 2              |                 |
| 110806           | 8              |                 |
| 111819           | 300            |                 |

~~260~~ 230 24 MD 09/10/05

# Picklist Print

Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D2741RevC  |                        | Manufactured  | No          |                     |                  | 260             | Each               | 40.0000        | 1.0000  |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |  |               |                |        |
| Blade, 350 Skidtube  |                        |               |             |                     |                  |                 |                    |                |   |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

47113 SC

D3532-1RevA

Manufactured No

260

Each

43.0000

2.0000



Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

38161 9/10/8 @ 9

# Picklist Print

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Wednesday, September 09, 2009 11:04:02 AM

Work Order ID: 51900



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| NAS1515H8L<br><br>WASHER |                        | Purchased     | No          |                     |                  | 260             | Each               | 127.0000       | 2.0000<br> |               |                |        |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

127

107581

34

108964

1

111650

92

111650 9/10/8 D SP

8 7 6 5 4 3 2 1

| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER   | DESCRIPTION   |
|-------------|-------------|-------------|-------------|---------------|---|
| X           |             |             |             | D2750-041     | 350 SKIDTUBE ASSEMBLY, LH                               |
|             | X           |             |             | D2750-042     | 350 SKIDTUBE ASSEMBLY, RH                               |
|             |             | X           |             | D2750-043     | 350 SKIDTUBE ASSEMBLY, LH                               |
|             |             |             | X           | D2750-044     | 350 SKIDTUBE ASSEMBLY, RH                               |
| 1           | 1           | 1           | 1           | D2739         | WEB   |
| 8           | 8           | 8           | 8           | D2743         | SPACER  |
| 1           | 1           | 1           | 1           | D2744         | CAP   |
| 8           | 8           | 8           | 8           | D2745         | BUSHING   |
| 1           |             |             |             | D2750-1       | SKIDTUBE WELDMENT, LH                                   |
|             | 1           |             |             | D2750-2       | SKIDTUBE WELDMENT, RH                                   |
|             |             | 1           |             | D2750-3       | SKIDTUBE WELDMENT, LH                                   |
|             |             |             | 1           | D2750-4       | SKIDTUBE WELDMENT, RH                                   |
| 1           |             | 1           |             | D3488-041     | BLADE FITTING, LH                                       |
|             | 1           |             | 1           | D3488-042     | BLADE FITTING, RH                                       |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER  |
| 4           | 4           |             |             | D3490-3       | SPACER  |
|             |             | 4           | 4           | D3490-5       | SPACER  |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY   |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY   |
|             |             | 8           | 8           | D3492-045     | PLUG ASSEMBLY   |
| 1           | 1           | 1           | 1           | D3535-25      | WEARSHOE  |
| 1           | 1           | 1           | 1           | D3536-25      | GASKET  |
| 3           | 3           | 3           | 3           | D3537-1       | WEARPAD   |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER  |
| 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE   |
| 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE  |
| 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE  |
| 1           | 1           | 1           | 1           | D3794-1       | GASKET  |
| 1           | 1           | 1           | 1           | D3794-3       | GASKET  |
| 38          | 38          | 38          | 38          | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34          | 34          | 34          | 34          | AN3C5A        | BOLT  |
| 4           | 4           | 4           | 4           | AN3C6A        | BOLT  |
| 4           | 4           | 4           | 4           | AN8C44A       | BOLT  |
| 1           | 1           | 1           | 1           | AN8C35A       | BOLT  |
| 38          | 38          | 38          | 38          | AN960C10L     | WASHER  |
| 1           | 1           | 1           | 1           | AN960C816L    | WASHER  |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT   |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT   |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER  |

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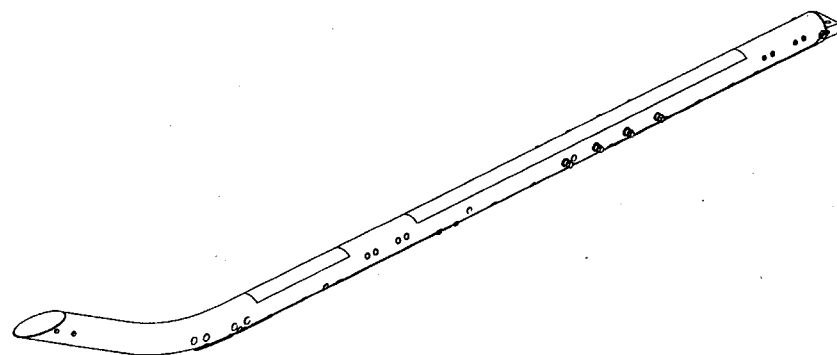
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

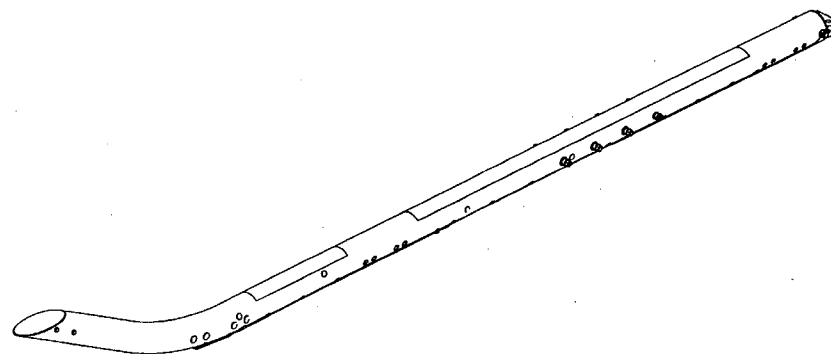
|            |   |    |          |
|------------|---|----|----------|
| F          | INCORPORATE DSI 9413;<br>QTY (3) D3537-1 WAS QTY (5) (ZN C8-1);<br>D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1);<br>D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1);<br>ADD D3791-1 (ZN C8-1);<br>WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED<br>(8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1);<br>D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11);<br>ADD NOTE 12 AND 13 (ZN A5-1);<br>REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E          | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1;<br>REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10)<br>NAS1515H8L; REMOVE D2741, QTY (2) AN960C816;<br>REMOVE QTY (2) MS21083C8  | CB | 07.05.17 |
| D          | ADD HOLES AND SPACERS FOR APICAL FLOATS;<br>INCORPORATE DEO 9133/9157   | PH | 06.01.05 |
| C          | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740  | CP | 98.11.18 |
| B          | CHANGE MS24694-S293 TO AN8-16A  | CP | 98.09.01 |
| A          | NEW ISSUE   | DS | 98.04.16 |
| REV.       | DESCRIPTION   | BY | DATE     |
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| DRAWN      |   |    |          |
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| TITLE<br>350 SKIDTUBE ASSEMBLY  | SCALE<br>NTS |
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

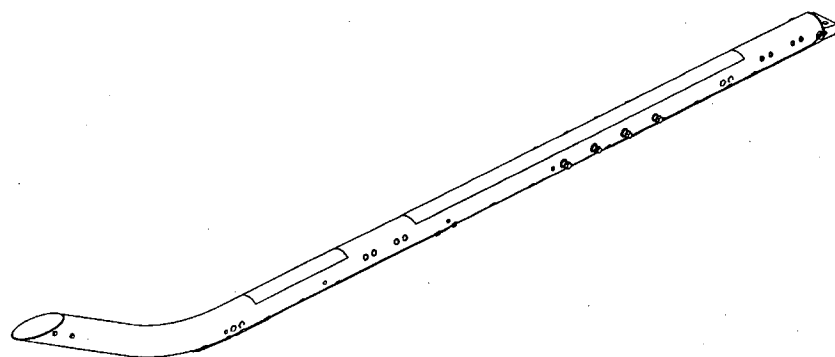


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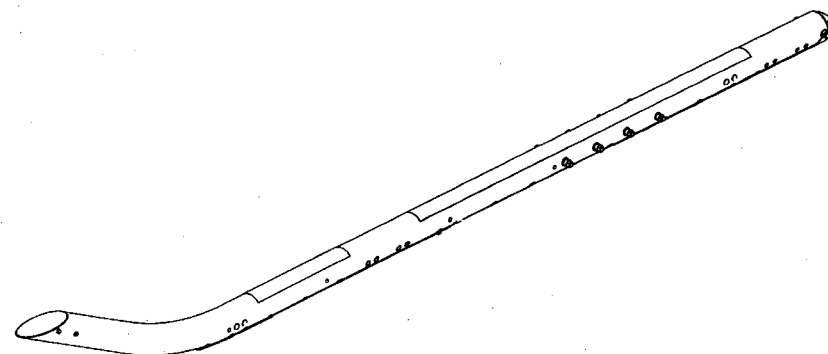
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



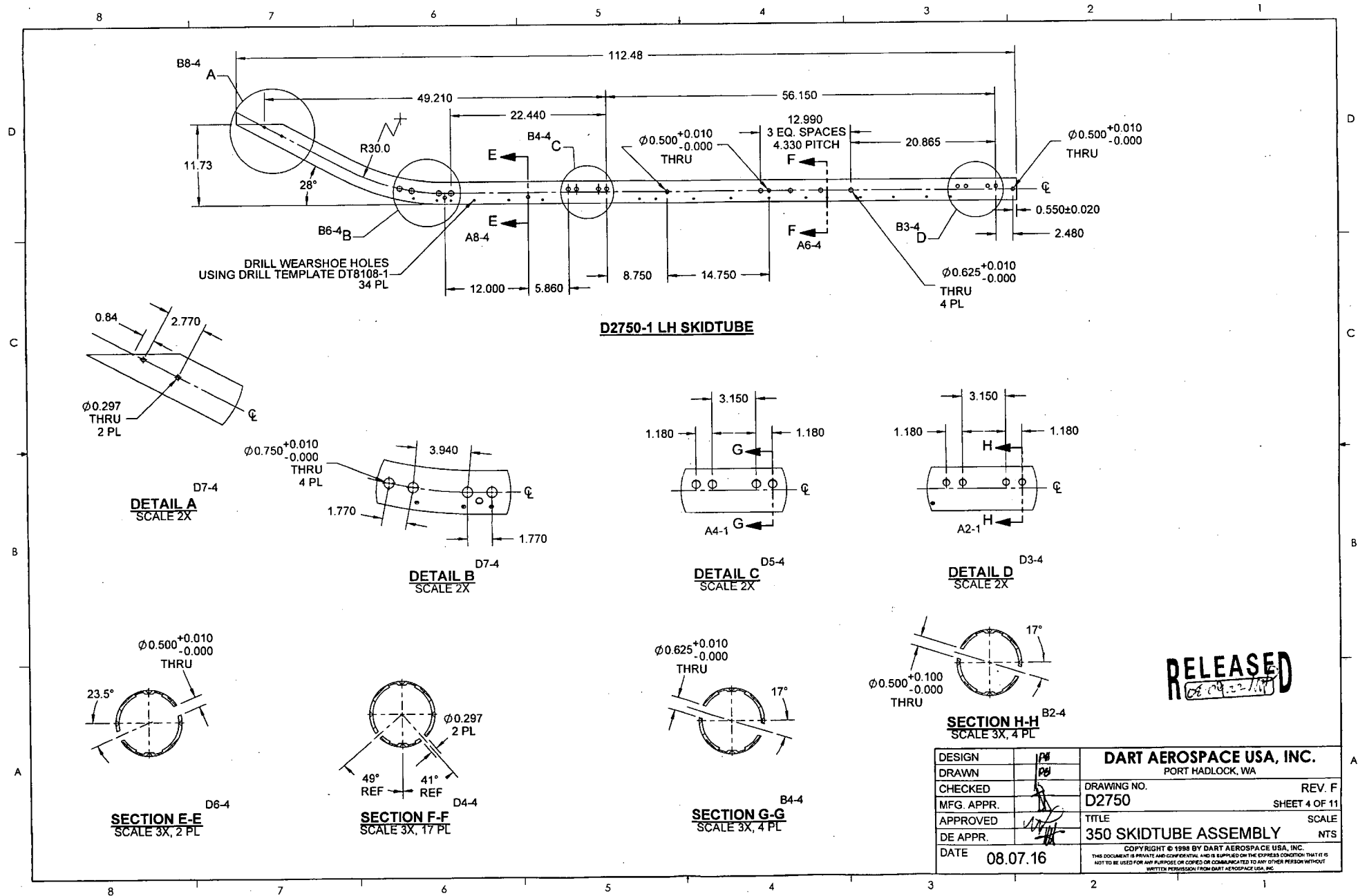
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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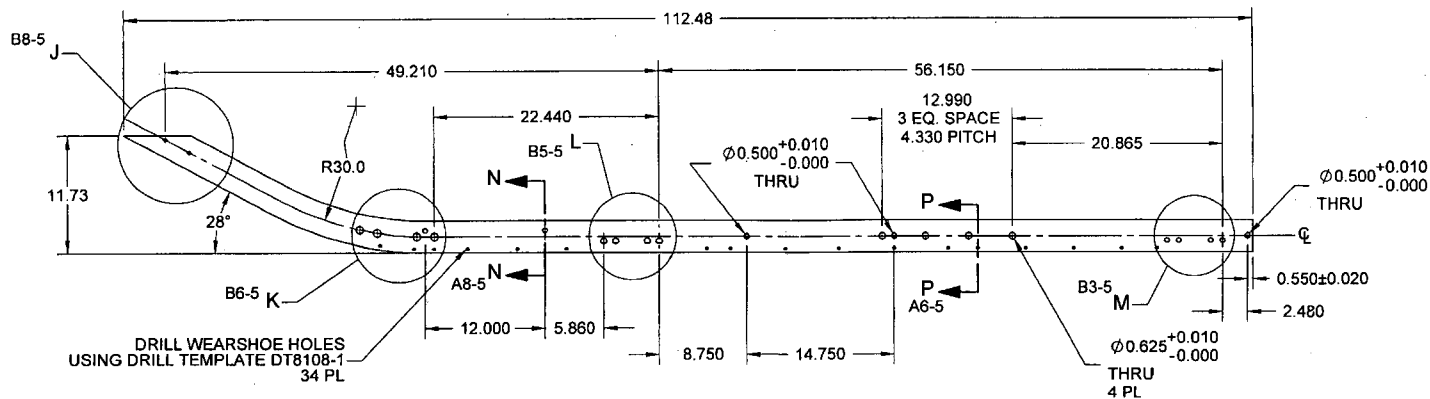
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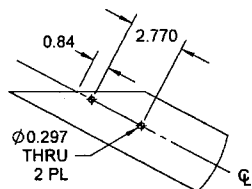
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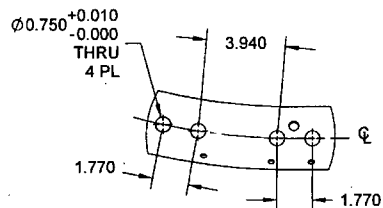
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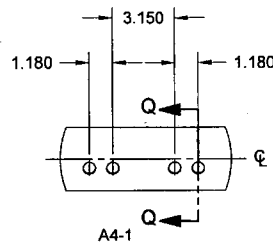
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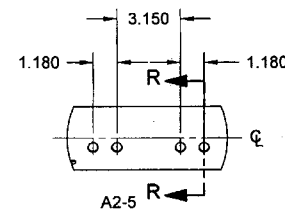
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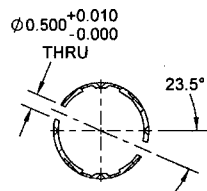
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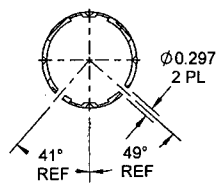
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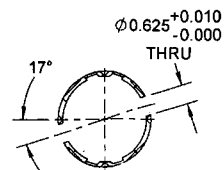
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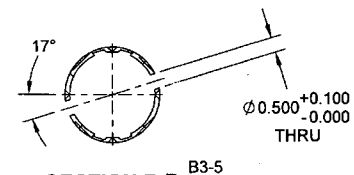
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

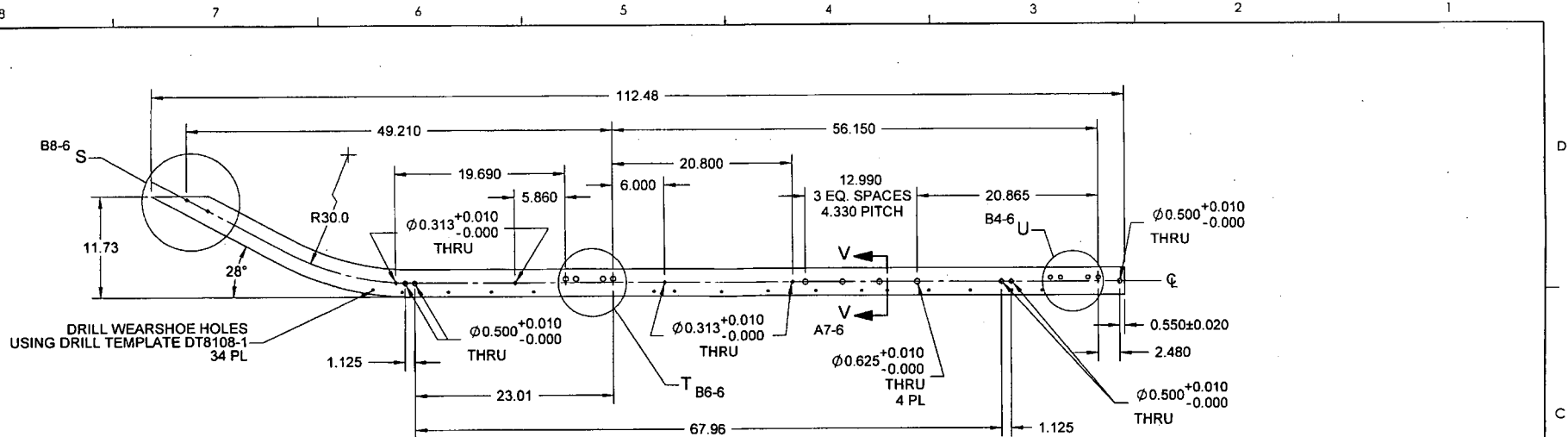


**SECTION R-R**  
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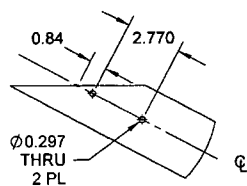
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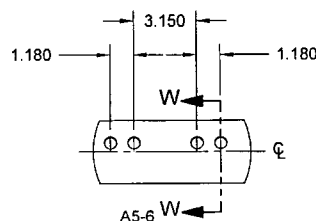
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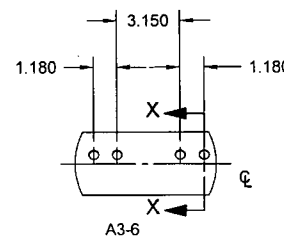
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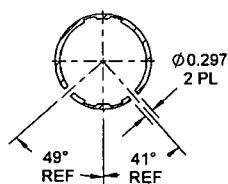
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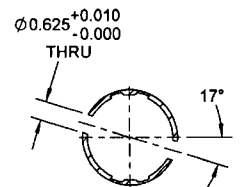
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C5-6  
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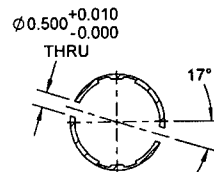
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL

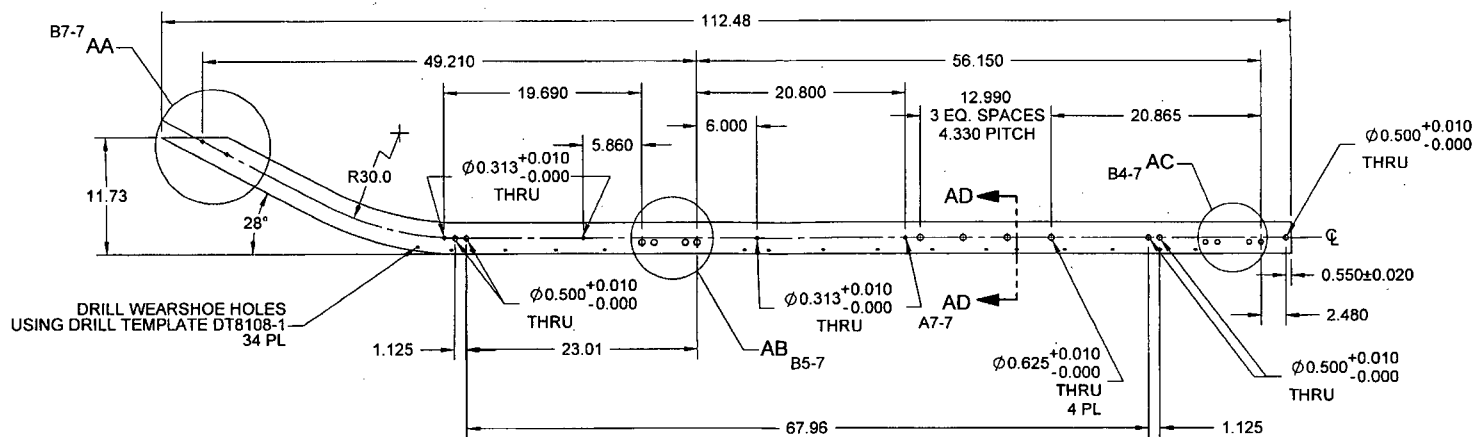


**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

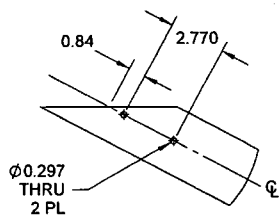
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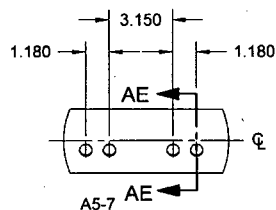
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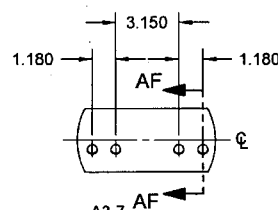
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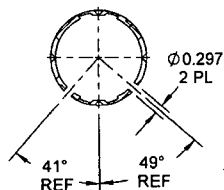
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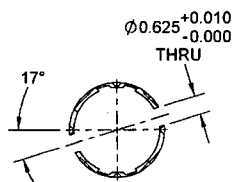
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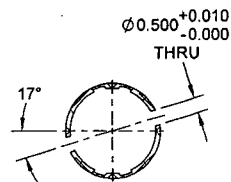
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

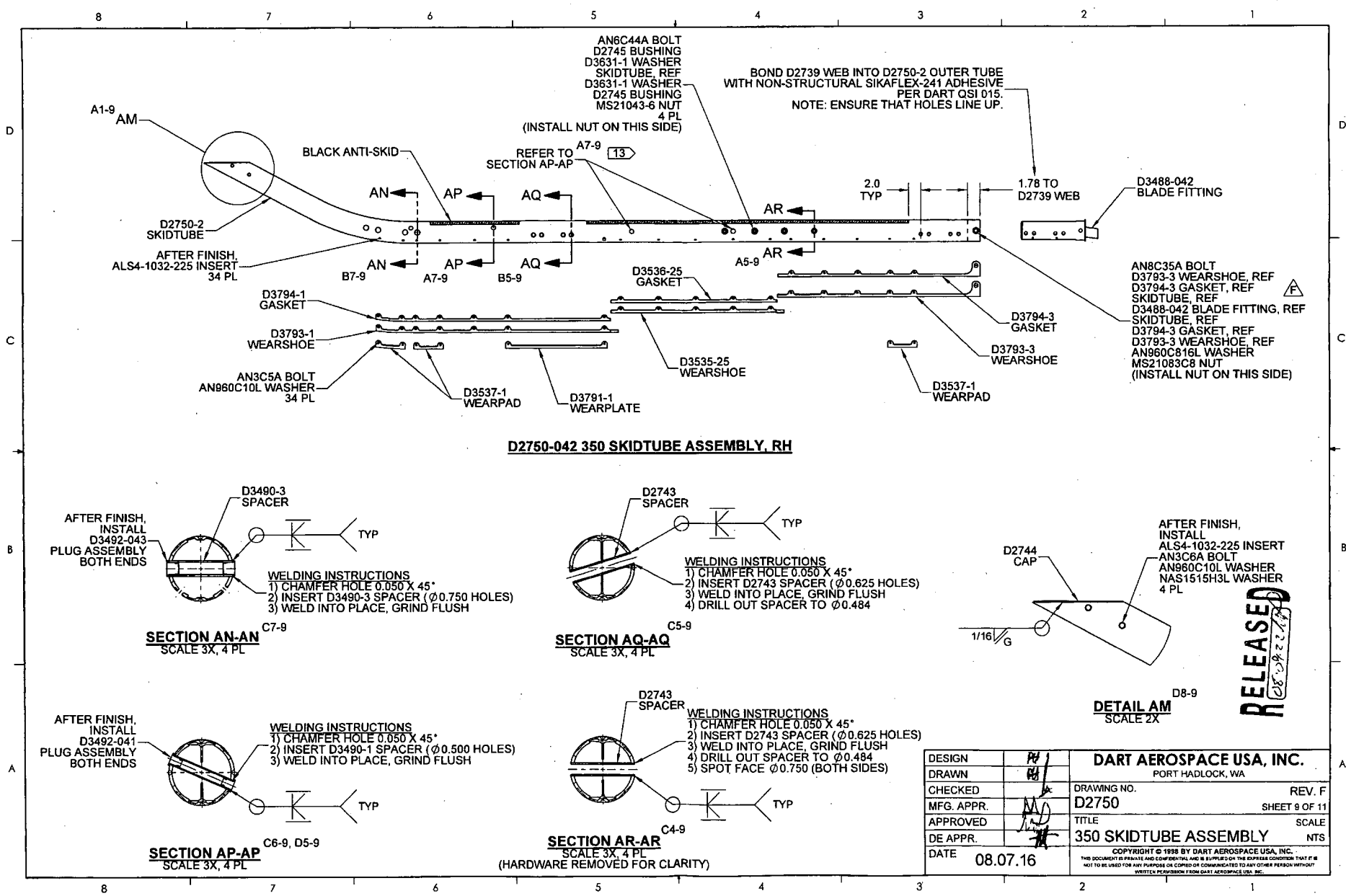
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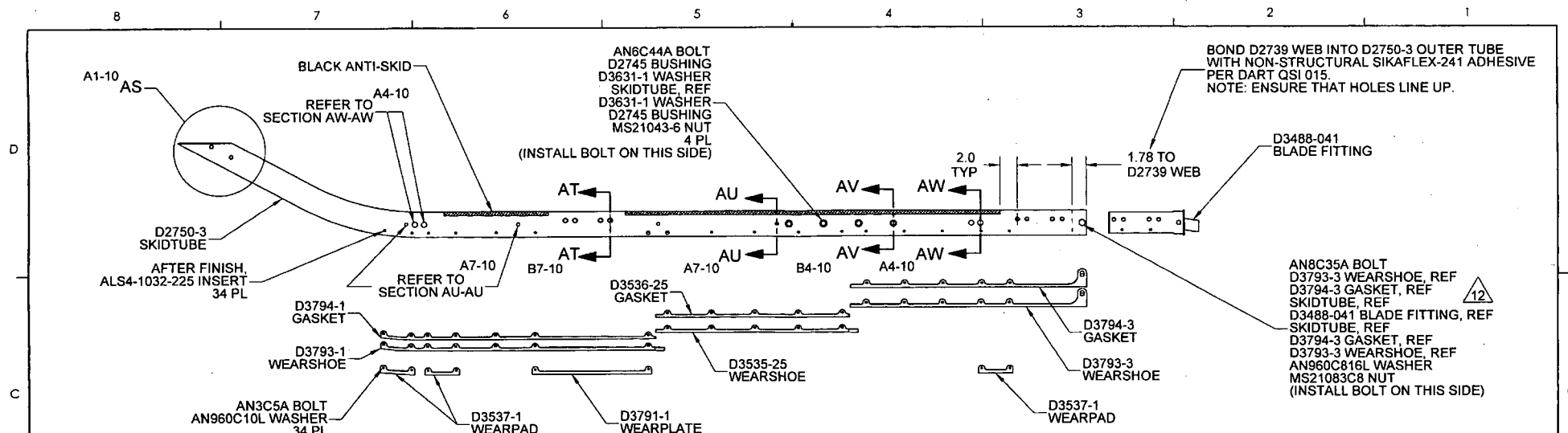
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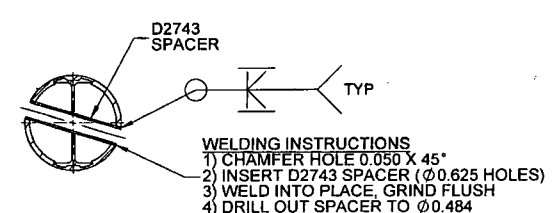
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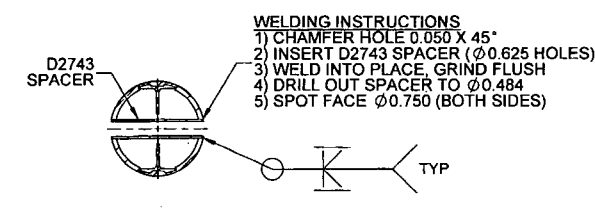
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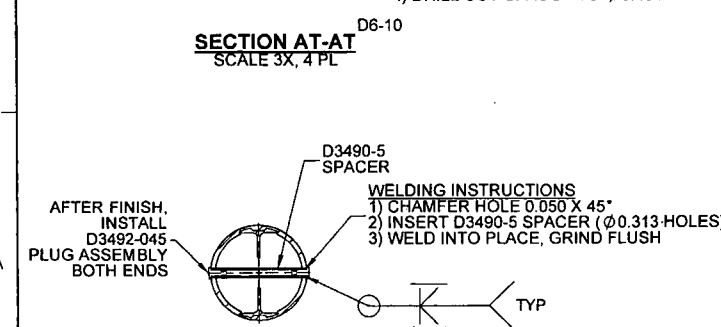
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



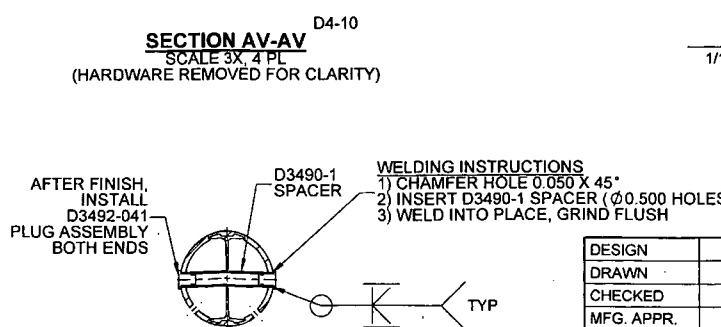
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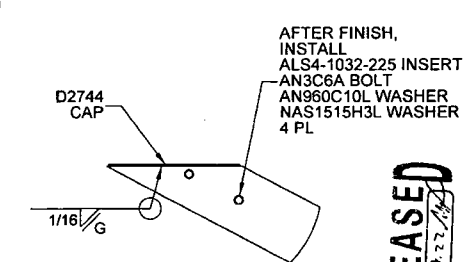
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SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL

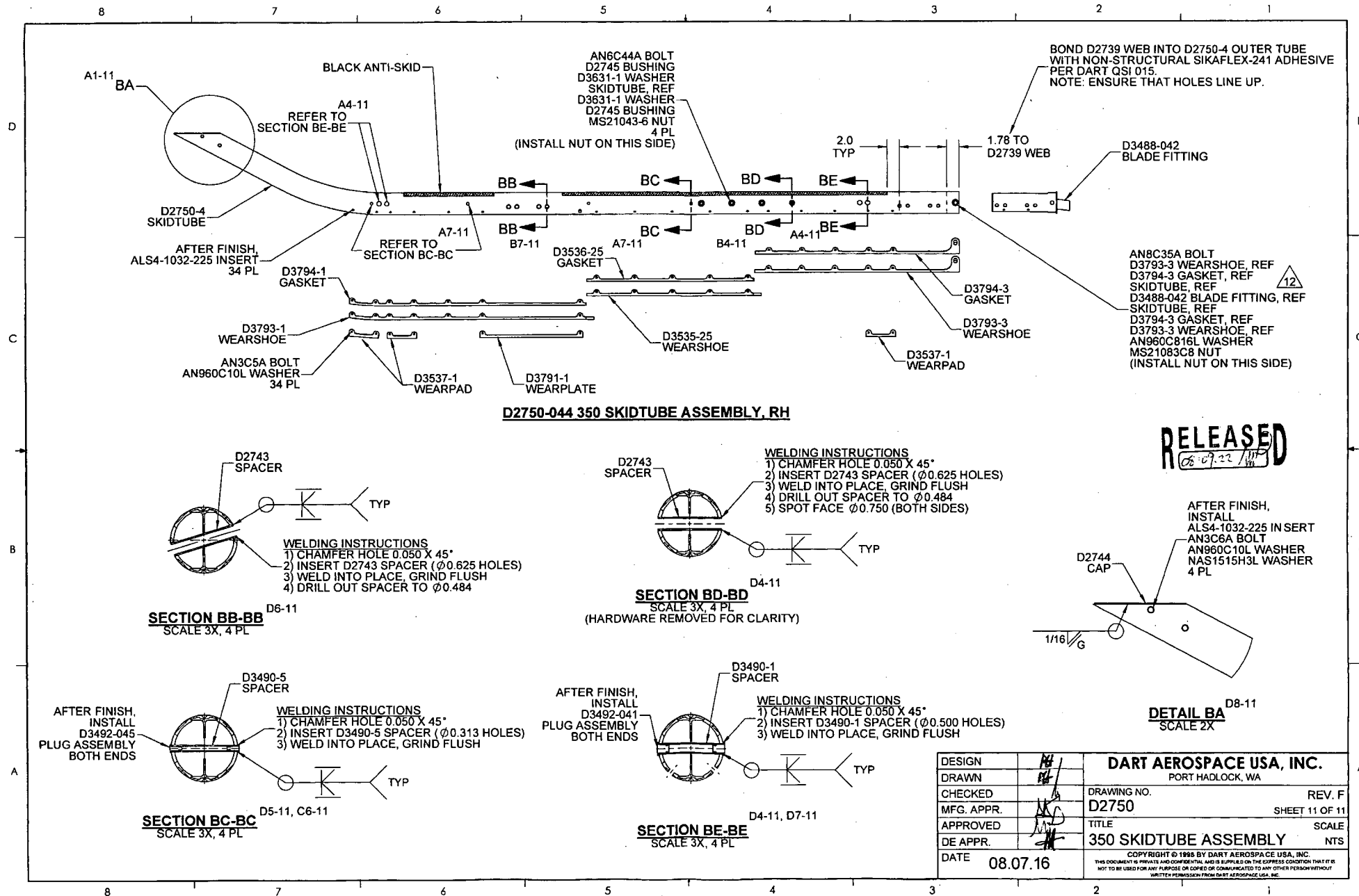


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| APPROVED   |                 | TITLE  | SCALE          |
| DE APPR.   |                 | <b>350 SKIDTUBE ASSEMBLY</b>   | NTS            |
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W/O 51900





NO. 209

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: A. Pat Axel  
Job number: 51803  
Part number: A350-636-011  
Description: 350 Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Daniel Axel Date of Test Coupon 09/09/08  
Welder A. Pat Axel Date of Test Coupon 09.09.08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld